

Work Order ID 73359

Wednesday, August 31, 2011 11:38:42 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 8/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/08/13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: 117884 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

PL 11-08-06 (X1)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-08-21 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	8/31/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	9/12/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							

Powder Coating	*** mask sides of hinge prior to powdercoat***								
	Start Time: 7:30								
	Oven Temperature: 320°F								
	Finish Time: 8:00								

140	Wing Walk as per dwg QSI005 4.4 Batch 11183103	0.00							
HandFinish	Memo	0.00							

Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg								
	2- Install placard and label as per dwg								
	***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***								

Handwritten signature: M. L. L. 8/31/11

Handwritten signature: M. L. L. 8/31/11

Handwritten: M115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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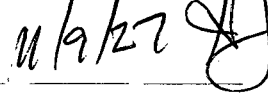
Item ID: D3914-041 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 8/31/2011 Start Qty: 1.00  Cust Item ID:
 Required Date: 9/12/2011 Req'd Qty: 1.00  Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	Suloe/22						
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160  Packaging Packaging	Identify as per dwg & Stock Location: <u>w/o</u> Memo	0.00 0.00	D4030-041 1373357 1 6 11 u/09/22						
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170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	u/09/22 						
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11-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 73359

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2581 Mounting Bracket		Manufactured	No			100	Each	19.0000	2	2		Ppl 11.08.06	
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Location	Loc Qty	Loc Code
WA	19	
69258	14	
69739	2	
70766	3	

D3914-1 Rib		Manufactured	No			100	Each	7.0000	2	2		Ppl 11.08.06	
--------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--------------	--

Location	Loc Qty	Loc Code
WA	7	
72087	3	
72656	4	

D3914-7 Rib		Manufactured	No			100	Each	8.0000	2	2		Ppl 11.08.06	
--------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--------------	--

Location	Loc Qty	Loc Code
WA	8	
71942	4	
72794	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 73359

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3
Hinge Half, Lid

Manufactured No

100 Each

19.0000

3 3

Ppl 11.08.06

Location

Loc Qty

Loc Code

WA

18

72116

18

WA005

1

71941

1

3

D4018-5

Rib

Manufactured No

100 Each

29.0000

9 9

Ppl 11.08.06

Location

Loc Qty

Loc Code

WA

29

70758

5

72339

5

72544

19

5 3

D4020-5

Mesh (350 Basket Long, Lid)

Manufactured No

100 Each

4.0000

1 1

Ppl 11.08.06

Location

Loc Qty

Loc Code

WA

4

68234

1

69162

1

71828

2

1

D4021-3

Data Plate

Manufactured No

100 Each

8.0000

1 1

Ppl 11.08.06

Location

Loc Qty

Loc Code

WA

8

71943

8

1

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 73359

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100

Each

5.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



Cpl 11.08.06

Location

Loc Qty

Loc Code

WA

5

63720

0

72541

1

72657

4

(1)

D4035-043

Manufactured No

100

Each

4.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



Cpl 11.08.06

Location

Loc Qty

Loc Code

WA

3

72542

3

WA006

1

72439

1

(1)

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



11115050

(x1) 11/09/22

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

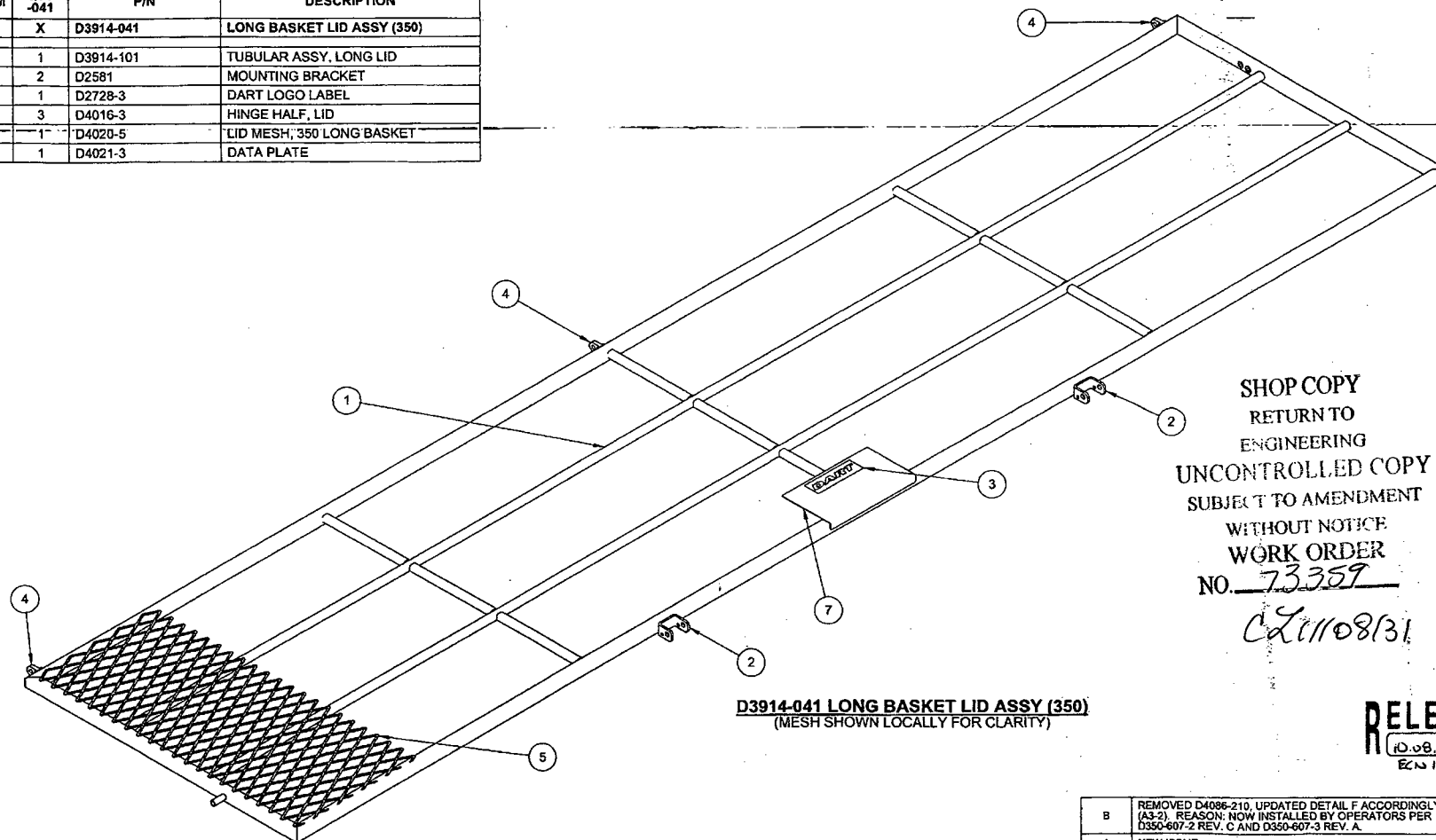
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



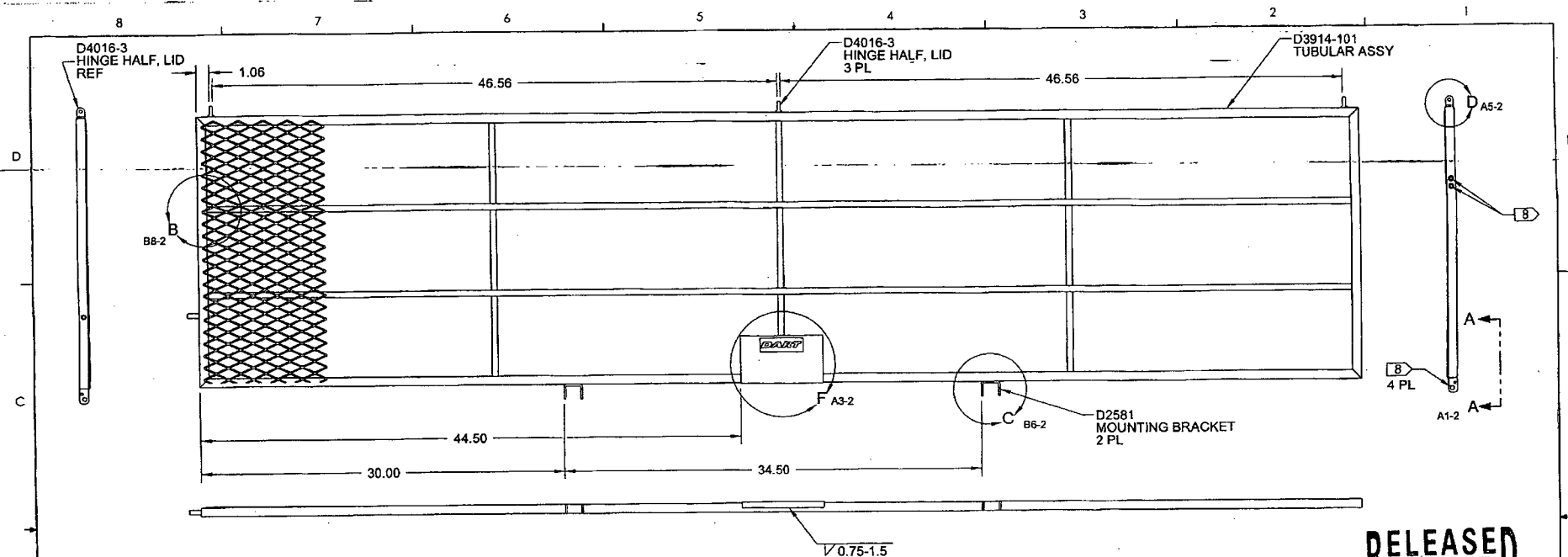
D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73359

CL 11/08/31

RELEASED
10.08.17
ECN 10-596

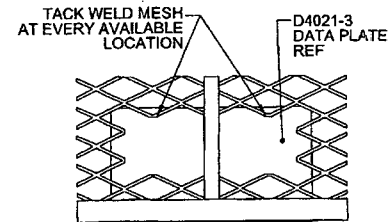
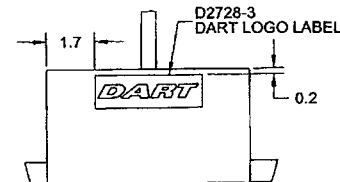
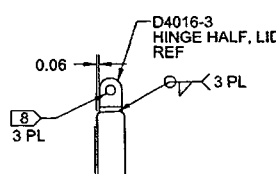
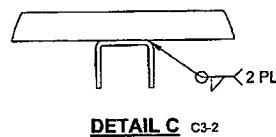
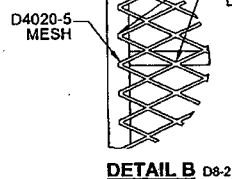
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>SC</i>	D3914	SHEET 1 OF 4
APPROVED	<i>SC</i>	TITLE	SCALE
DE APPR.	<i>SC</i>	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED
10-08-12 UP

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

